

Work Order ID 64207

Tuesday, November 30, 2010 11:30:06 AM

Page 1

Item ID: D4075-1KGY

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Overhead, Center

Start Date: 11/30/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4075	A

100

0.00



Hand Thermo

Memo

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

0.00

x2

OK
10/12/2

105

0.00



Hand Thermo

Memo

Hand Finishing Thermoforming

Dry Sheet as per QS1022 KYDEX

0.00

Temp: 150°F

Time IN: 4:30 pm 10/12/1

Time OUT: 7:00 am 10/12/2

OK
10/12/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:




Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00				x2			Dh. 10/12/2
Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA083 using tool DT9256 Dwg Rev: <u>A</u> Folio Rev: <u>A</u>	0.00							
120 	QC2- Inspect parts off machine FAI/FAIB	0.00				x2			Dh. 10/12/2
QC	Memo	0.00							
Quality Control	Visually inspect part for proper formation and texture								
130 	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

810/12/2

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Tuesday, November 30, 2010 11:30:07 AM

Page 3

Item ID: D4075-1KGY

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Start Date: 11/30/2010 Start Qty: 2.00

Required Date: 12/14/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

2

BB
10/12/13

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

2

BB
10/12/13

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. W. H. S.

BB

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Start Date: 11/30/2010 Start Qty: 2.00

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Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPPL64207

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 30, 2010 11:30:05 AM

Page 1

Work Order ID: 64207



Parent Item: D4075-1KGY



Parent Item Name: Rear Overhead, Center

Start Date: 11/30/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 10/11/30 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	393.5600	14.34	28.82412			



Kydex steel grey



Location

Loc Qty

Loc Code

therm

393.56

393.56

11807

29.68 sg ft.

10/12/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

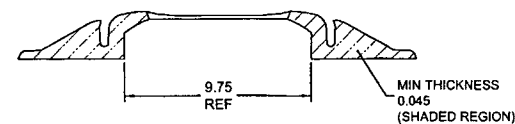
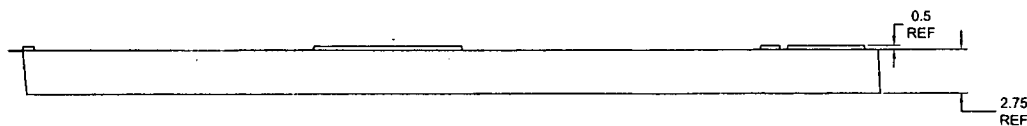
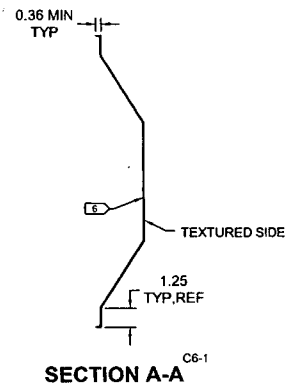
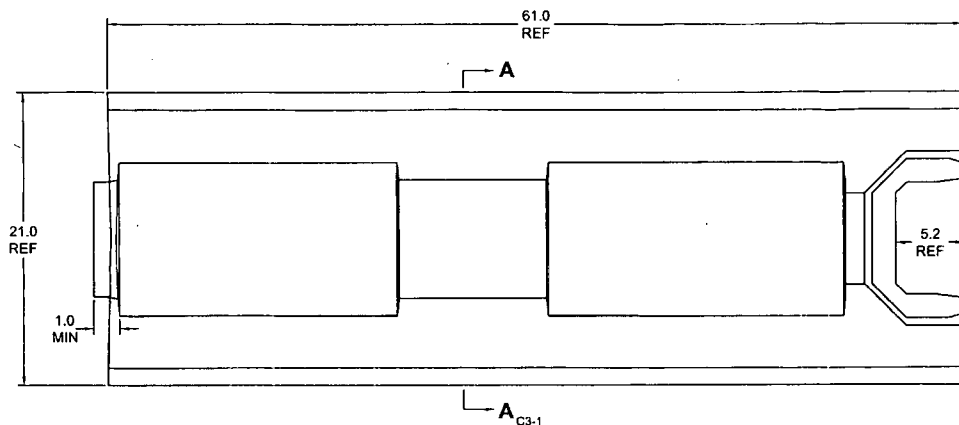
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64207



D4075-1 REAR OVERHEAD, CENTER

RELEASED
2010-11-20

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 4.3 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9256 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D4075-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D4075-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	SC	10.10.21
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	U	DRAWING NO.	REV. A
MFG. APPR.	U	D4075	SHEET 1 OF 1
APPROVED	U	TITLE	SCALE
DE APPR.	U	REAR OVERHEAD (BELL 206 L/L1) NTS	
DATE	10.10.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 64207
Description: REAR OVER HEAD CASTER	Part Number: D4075-1K6Y
Inspection Dwg: 4075 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB	Date: 10/11/13
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
61.0	REF	60.8	✓			
21.0	REF	21.6	✓			
1.0	MIN	1.06	✓			
0.36 .36	MIN	.40	✓			
.045	MIN	.059	✓			

Measured by: JB	Date: 10/12/13
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Audited by: S	Date: 10/12/23
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14